Work Order ID 66664

Wednesday, February 23, 2011 1:13:28 PM

Item ID: D2563 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Step Weldment Assembly

Start Date: 2/23/2011 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 3/4/2011 **Req'd Qty:** 4.00 **Customer:**

Reference:

Approvals: **Process Plan:** CL **Date:** 11/02/23 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2563	Rev C								
100		0.00				11·03·31	4		
Large Fab	Large Fab								
Large Fab	**Memo**	0.00							
Large Fab	1-Cut D2244 to 89.70" at 34 deg as per dwg D2563 2-Deburr ends 3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343 4- Grind								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00				4	0	BB 11/03/31	
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00				4			
QC	Memo	0.00							
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00				4	0	11/03/31	
HandFinish	Memo	0.00							
Hand Finishing									
140	QC3- Inspect Part Finish	0.00				4		BR 11-03-31	
QC	Memo	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NOTE: Date & initial all entries

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Weld per dwg A/R Aluminum rod Batch: M114703	0.00							
Large Fab	Large Fab								
Large Fab	**Memo**	0.00							
	1-Inspect for foreign object per QSI 024								
	2-Weld Remainig End cap as per Dwg D2563 using DT 8343								
	3-Grind								
160	~~QC9~~ QC10 Inspect visual per QSI004- Fusion Welds	0.00							
QC	**Memo**	0.00							
Quality Control									
170	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O: 66664		WORK ORDER CHANGES						
DATE	**STEP**	Perm. change **PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector
4/04/01	* 160	change to QC10 inspection			11.04.06			S 4/04/01

Part No: D2563 **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 66664

Wednesday, February 23, 2011 1:13:28 PM

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Revision ID:

Item Name: Step Weldment Assembly

Start Date: 2/23/2011 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 3/4/2011 **Req'd Qty:** 4.00 **Customer:**

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Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
175	Pressure Wash per QSI005 4.3	0.00				4X			
HandFinish	**Memo**	0.00							
Hand Finishing	Touch up Alodine as per QSI005								
180	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				4X			
Powdercoat	**Memo**	0.00							
Powder Coating	Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 START TIME: 10:40 OVEN TEMPERATURE: 320°F FINISH TIME: 11:10								
190	Wing Walk as per dwg QSI005 4.4 Batch AA116 4020	0.00				4X			
HandFinish	**Memo**	0.00							
Hand Finishing									

11/04/02

11/04/02

11/04/02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

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Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng		**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 66664

Wednesday, February 23, 2011 1:13:28 PM

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Item Name: Step Weldment Assembly

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Required Date: 3/4/2011 **Req'd Qty:** 4.00 **Customer:**

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Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC3- Inspect Part Finish	0.00				4	BR	11-4-4	
QC	**Memo**	0.00							
Quality Control									
210	Identify as per dwg & Stock Location:_____	0.00 PPP 66666				11/4/6 SP	(4)		
Packaging	**Memo**	0.00							
Packaging									
220	QC21- Final Inspection - Work Order Release	0.00						11/4/6	
QC	**Memo**	0.00							
Quality Control									

JMF 11-04-04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, February 23, 2011 1:13:25 PM

Work Order ID: 66664

Parent Item: D2563

Parent Item Name: Step Weldment Assembly

Start Date: 2/23/2011 **Required Date:** 3/4/2011

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP Rev:G 02.07.31 Re-format Location RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2244-116		Manufactured	No			100	Each	104.0000	1	4		11.03.05	
Step Extrusion													
				Location			**Loc Qty**		**Loc Code**				
				WA			104						
					57850		27				2		
					60307		77				2		
D2561		Manufactured	No			100	Each	7.0000	2	8		11.03.30	
Lug													
				Location			**Loc Qty**		**Loc Code**				
				WA	366813		7				7		
					60096		7				1		
D2564		Manufactured	No			100	Each	17.0000	2	8		11.03.30	
Mounting Angle													
				Location			**Loc Qty**		**Loc Code**				
				WA			17						
					62951		17				8		
D2673-34		Manufactured	No			100	Each	144.0000	1	4		11.03.30	
End Plate													
				Location			**Loc Qty**		**Loc Code**				
				WA			144						
					57527		1						
					59690		143				4		

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W/O:		WORK ORDER CHANGES						
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Work Order ID: 66664

Parent Item: D2563

Parent Item Name: Step Weldment Assembly

Start Date: 2/23/2011 **Required Date:** 3/4/2011

Start Qty: 4.00 **Required Qty:** 4.00

D2673-34	Manufactured	No		150	Each	144.0000	1	4

End Plate

11.03.31

Location	Loc Qty	Loc Code
WA	144	
57527	1	
~~59690~~	143	

4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
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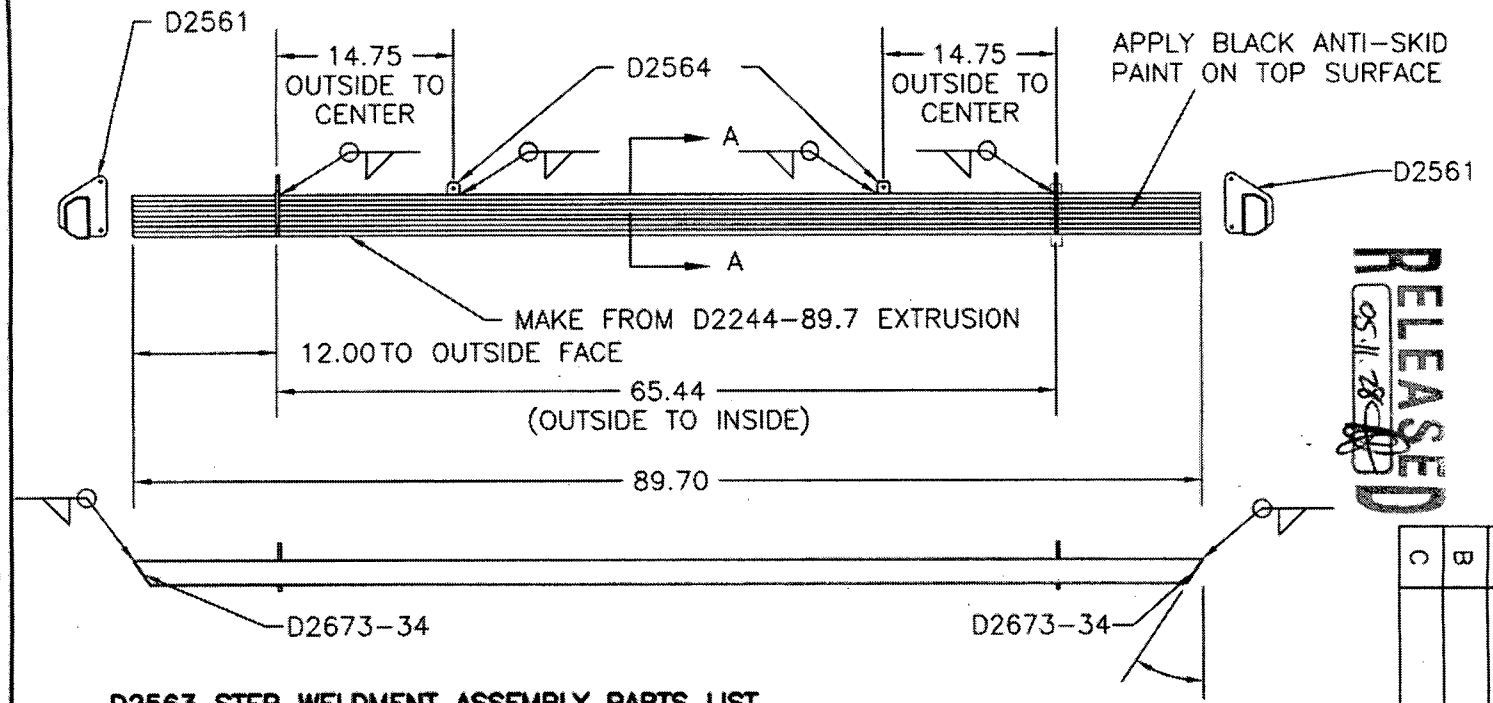
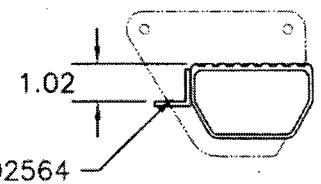


RELEASED
05.11.28

D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing



SECTION A-A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 166664
C 2111023

D2563 STEP WELDMENT ASSEMBLY NOTES

1) MAKE FROM EXTRUSION D2244
2) WELD PER DART QSI 004
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) ALL DIMENSIONS ARE IN INCHES
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

C	05.11.14	UPDATE NOTES
B	97.05.14	END CAPS CHANGED (WAS D2248)
A	96.04.26	NEW ISSUE

DESIGN BW | DRAWN BY | CHECKED | APPROVED | DATE 05.11.14

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2563 REV. C
TITLE STEP WELDMENT ASSEMBLY
SHEET 1 OF 1
SCALE 1:15